

Date: Wednesday, 1/31/2007 2:19:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 30563A		
Estimate Number	: 10452		
P.O. Number	: N/A	Part Number	: D32781
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Number	: D3278 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 30276A	Material	: N/A
Written By	: <u>JA</u>	Due Date	: 2/28/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>JA 07.02.01</u>		
Comment	: Est:A 04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0 f(s)/Unit Total : 5 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
 (M6061T6B1.000x02.000) Batch: M19295

ml 07/02/17

27

2.0	SHEAR <u>STW</u>	SHEAR
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Comment: SHEAR
 Cut blank: 2.00" x 1.00" x 2.550" long

ml 07/02/17

27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA405 and Dwg D3278
 2- Deburr and Tumble
 Identify as D3278-1

ml 07/02/18

27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/02/18

27

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07/02/24 (27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: ~~Yes~~ No DQA: LD Date: 07/07/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:19:42 PM
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Drawing Name: SUPPORT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(27x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MA/YL

07/02/26

7.0

POWDER COATING

POWDER COATING



m/03/41

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR/M.A 07/02/26 (27)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/2/28 (27)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5 B 7/2/28 (27)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(27)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/28

Job Completion



U 07-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30563A
Description: Support		Part Number: D3278-1
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.098	—			
0.359	+/-0.005	0.359	—			
0.615	+/-0.010	0.615	—			
0.250	+/-0.010	0.250	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	R0.125	—			
0.119	+0.005/-0.004	0.123	—			
2.439	+/-0.010	2.437	—			
1.980	+/-0.010	1.983	—			
R0.130	+/-0.010	R0.130	—			
Ø0.257	+0.005/-0.000	Ø0.257	—			
R0.375	+/-0.010	R0.375	—			
0.875	+/-0.010	0.875	—			
0.500	+/-0.010	0.500	—			
R0.400	+/-0.010	R0.400	—			
1.720	+/-0.010	1.719	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.126	—			

Measured by: <i>[Signature]</i>	Audited by: J.L.	Prototype Approval:	N/A
Date: 07/02/18	Date: 07/02/18	Date:	N/A

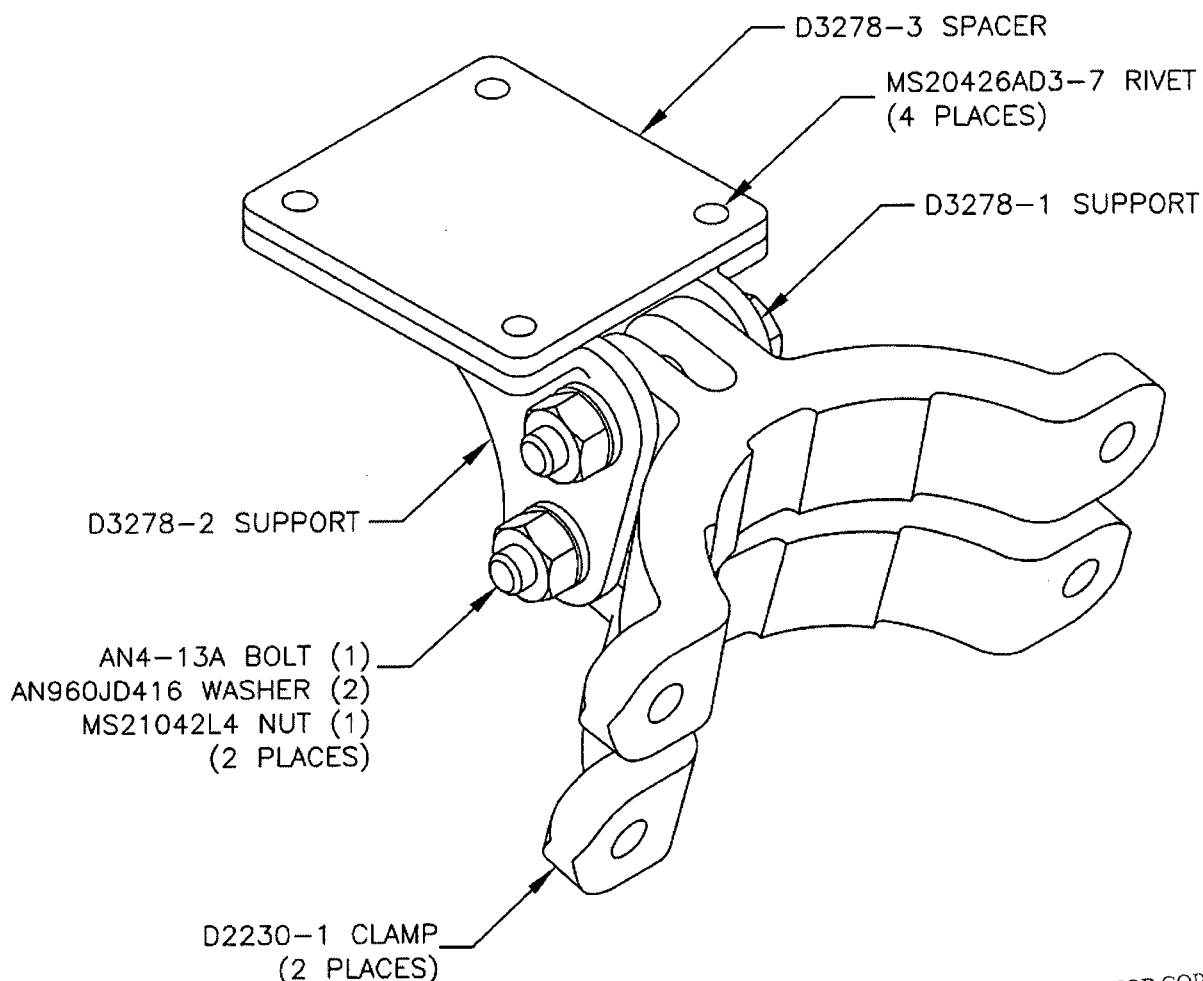
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	<i>[Signature]</i>



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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



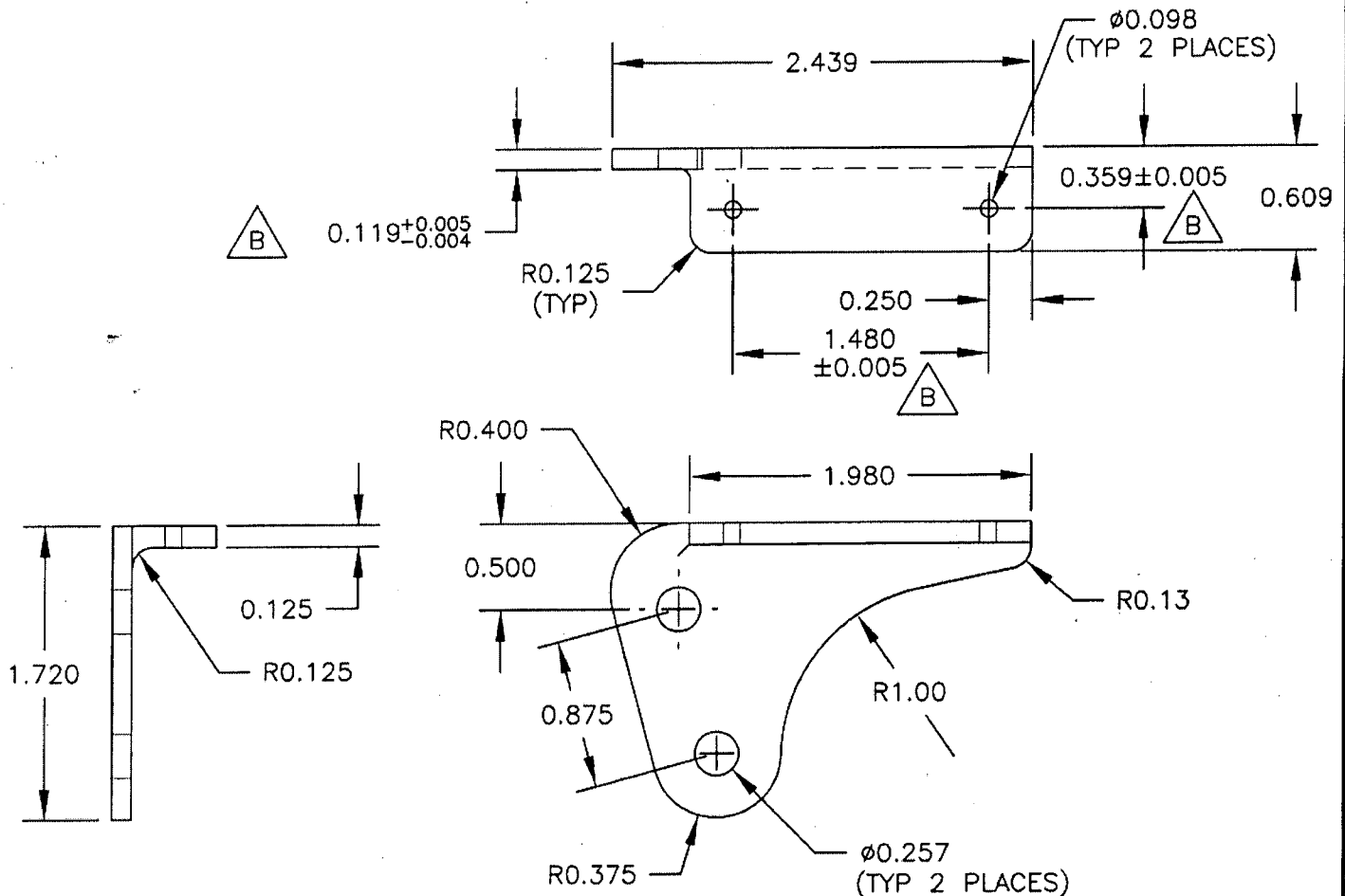
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

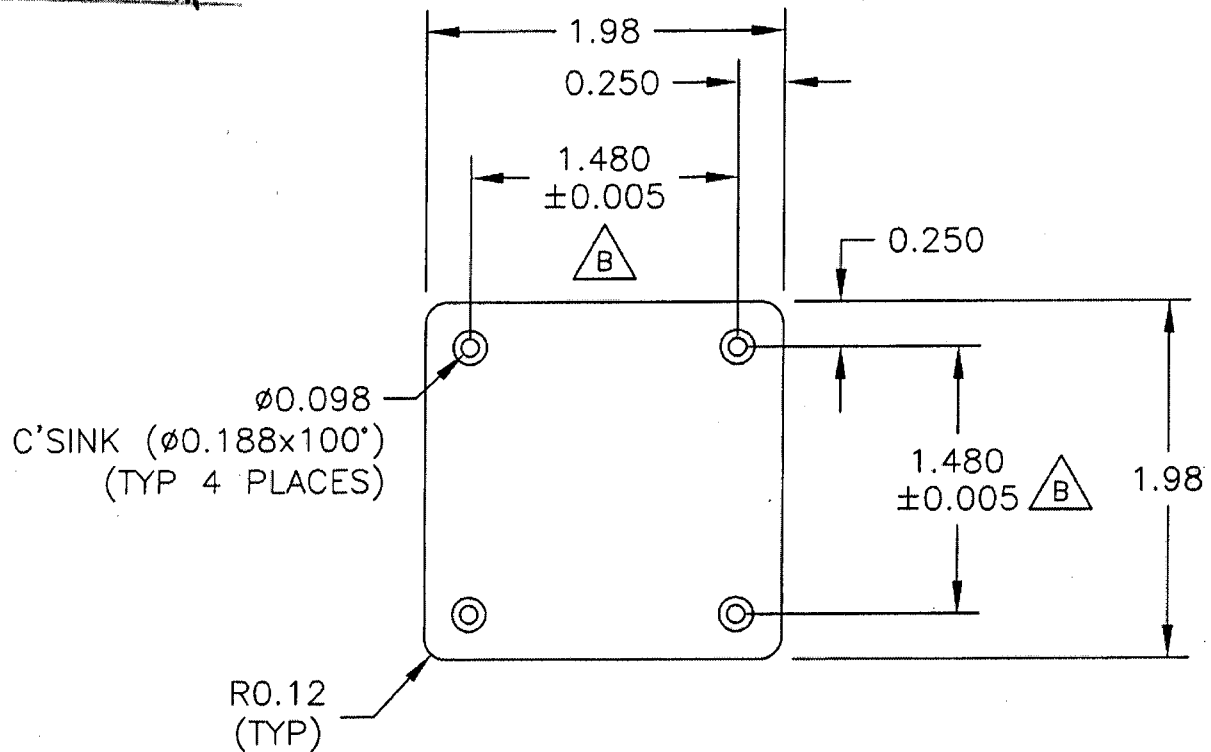
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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